

Work Order ID 69172

Tuesday, May 03, 2011 2:12:34 PM



Page 1

Item ID: D4334-7

Accept



Setup Start



Revision ID: PRELIM

Item Name: Fairing

Stop



Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 1.00



Customer:

PRELIMINARY ISSUE

Reference:

Approvals: Process Plan: MF

Date: 11-05-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4334	PA9

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

xl

u/11/05/03

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°C

Time IN: 2:00 am

11/05/03

Time OUT: 2:00 am

11/05/03

xl

u/11/05/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 2

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

6 10091001 000110 856 1301 100

**Insp.
Stamp**

0.00

0.00

Memo

1-Machine Set-Up

2-Pre-heat Tool to required temp.

3-Thermoform as per Dwg and Folio #FTA106 using tool DT9717

Dwg Rev: PA9.

Folio Rev: Δ

0.00

0.00

Memo

Visually inspect part for proper formation and texture

0.00

0.00

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x1

11/05/04

150

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

x1

11/05/04

160

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

inspected to PAS

Due only

8/10/04 @

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

11

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*Eagle***POSITIVE RECALL**EFFECTIVE 11.05.03 AUTH HA

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 03, 2011 2:12:27 PM

Page 1

Work Order ID: 69172



Parent Item: D4334-7



Parent Item Name: Fairing


Start Date: 5/3/2011

Required Date: 5/3/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 11/04/012 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 		Purchased	No			100	sf	1,887.547	3.46875	3.46875			
GE PLASTICS LEXAN SHEET													

Location

MAT018

Loc Qty

1887.547789

Loc Code

115261

5.332

116236

1882.21579

3.46875 sf PL.

Handwritten signature
11/05/04

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order: 69172.
Description:	Part Number: D4334-7
Inspection Dwg: D4334-7 Rev: PA9.	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 1/4 " <i>DR</i>	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <i>DR</i>	Date: 11/05/04
-------------------------------	-----------------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.7"	$\pm 0.100"$	7.625"	✓		TAPE DL-01	
6.6"	$\pm 0.100"$	6.55"	✓		TAPE DL-01	
3.6"	$\pm 0.100"$	3.61"	✓		VERN DL-02	
2.6"	$\pm 0.100"$	2.73"	✗	✓	VERN DL-02	See attached e-mail
3.6"	$\pm 0.100"$	3.71"	✓		VERN DL-02	
3.4"	$\pm 0.100"$	3.4"	✓		VERN DL-02	

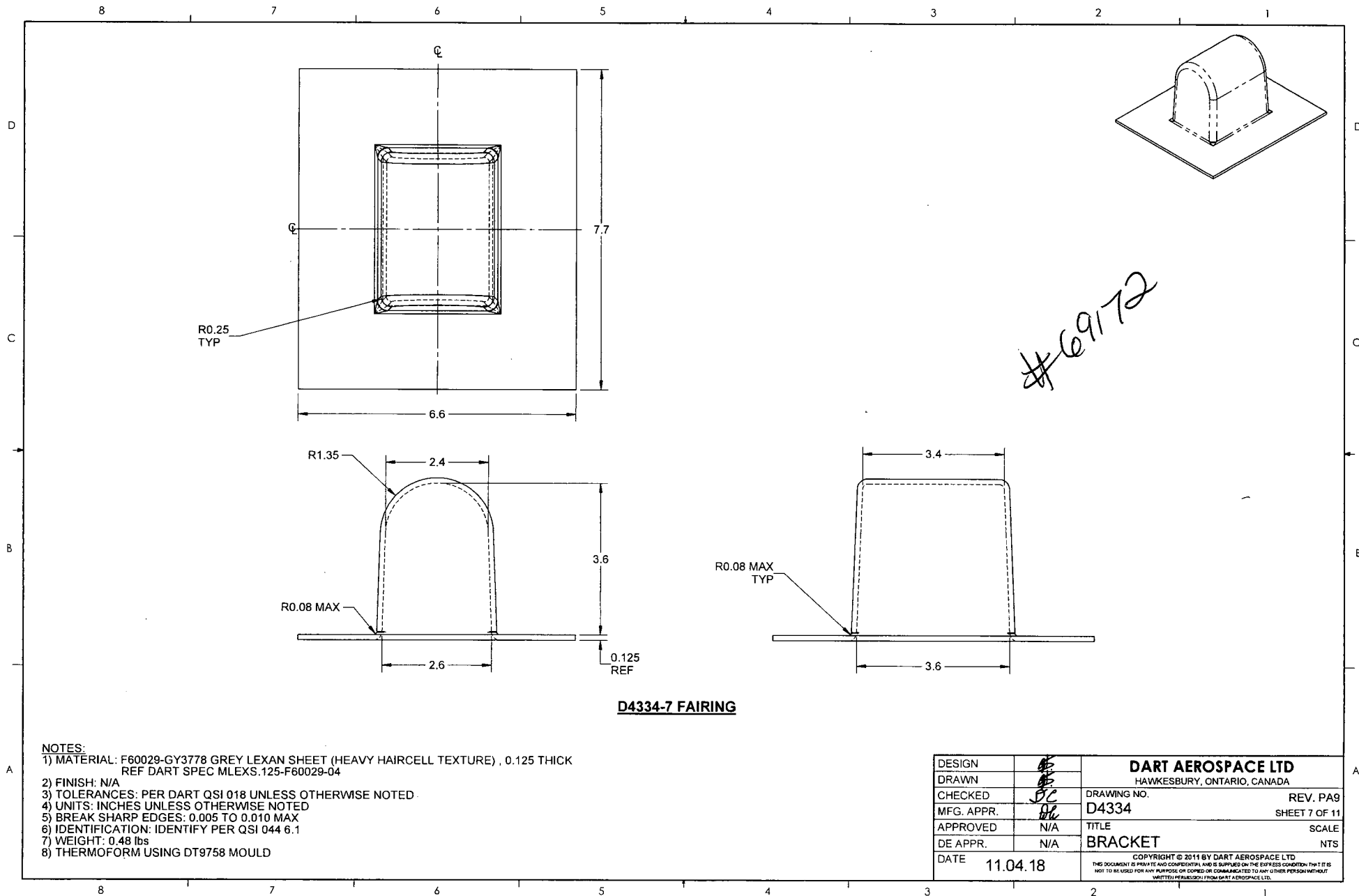
Measured by: <i>DR</i>	Date: 11/05/04
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Audited by: <i>S N PA9 Dm al</i>	Date: 11/05/04
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) , 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.48 lbs
- 8) THERMOFORM USING DT9758 MOULD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA9
MFG. APPR.		D4334	SHEET 7 OF 11
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	BRACKET	NTS
DATE	11.04.18	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Wednesday, May 04, 2011 9:48 AM
To: Daryl Leger
Cc: 'Harvey Siemens'
Subject: D4334-7

Hi Daryl,

As per our phone conversation, it should not be an issue that the 2.6" dimension on the dwg is closer to 2.73" on the part.

Cheers,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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